Work Order ID 65449

Monday, January 17, 2011 4:09:43 PM

Item ID: D4055-5 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Tank Upper Cut Out

Start Date: 1/18/2011 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 2/1/2011 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** MF **Date:** 11-01-18 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4055	A								
100		0.00							
Purchasing									
Purchasing	**Memo**	0.00				CL 11/01/18		(2)	
	Issue P/O: 13307 Purchase part as per Dwg D4055 Possible Supplier: GFI Material release note required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging									
Packaging	**Memo**	0.00				1/4/16		(2)	
120	QC6- Inspect dimensions to drawing	0.00							
QC									
Quality Control	**Memo**	0.00	8/10/17			(2)			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 65449

Monday, January 17, 2011 4:09:43 PM

Item ID: D4055-5 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Tank Upper Cut Out

Start Date: 1/18/2011 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 2/1/2011 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00				2	0	10	11/02/22
HandFinish	**Memo**	0.00							
Hand Finishing									
140	QC3- Inspect Part Finish	0.00				2		BL	11-02-22
QC	**Memo**	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: 119	0.00							11/2/22
Packaging	**Memo**	0.00							
Packaging									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 65449

Monday, January 17, 2011 4:09:43 PM

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Item Name: Tank Upper Cut Out

Start Date: 1/18/2011 **Start Qty:** 2.00 **Cust Item ID:**

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Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00						11/02/23	
QC	**Memo**	0.00							
Quality Control									

MF
11-02-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Monday, January 17, 2011 4:09:40 PM

Work Order ID: 65449

Parent Item: D4055-5

Parent Item Name: Tank Upper Cut Out

Start Date: 1/18/2011 **Required Date:** 2/1/2011

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4055-5P Tank Upper Cut Out		Purchased	No			110	Each	0.0000	1	2			

Dart Aerospace Ltd

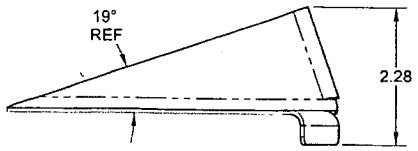
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

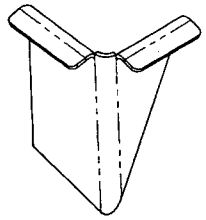
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

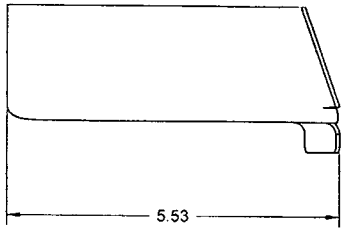
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

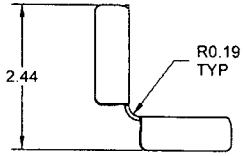
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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries









#65449

RELEASED
2010-05-05
MP

D4055-5 UPPER CUT OUT

NOTES:
1) MATERIAL: MADE FROM D4055-5F
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.10 lbs

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	10.04.16

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.	REV. A
D4055	SHEET 8 OF 15
TITLE	SCALE
TANK	NTS

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Dart Aerospace Ltd

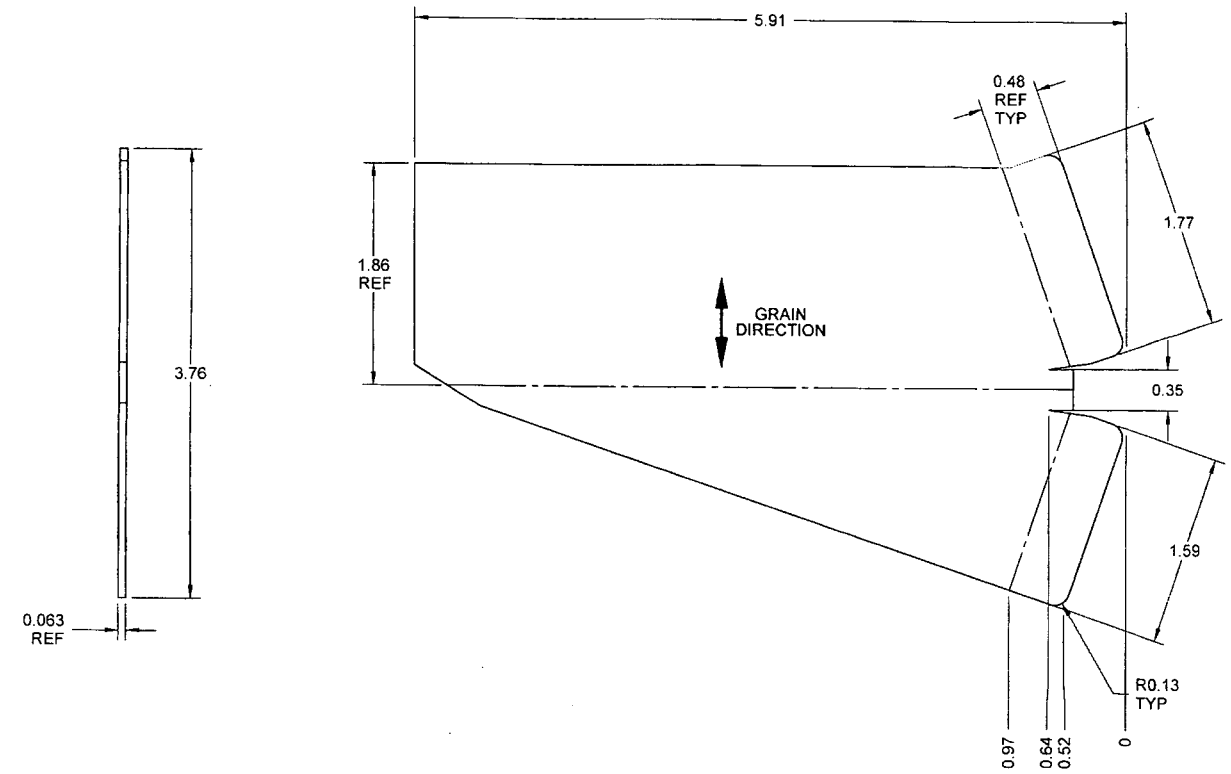
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



#63449

RELEASED
2010-05-05

D4055-5F FLAT PATTERN

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.10 lbs

DESIGN		**DART AEROSPACE LTD**
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4055 — REV. A
MFG. APPR.		SHEET 9 OF 15
APPROVED		TITLE: TANK — SCALE: NTS
DE APPR.		
DATE	10.04.16	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE

Membre de / A Member of Thomas&Betts

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. **3** OUR JOB NO **J0226099** SHIPPING MEMO **0455817**

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
--	2 PCS	PO13307	D4055-5P	A	TANK UPPER CUT OUT	A

MATERIAL	SUPPLIED BY	MAT. REL. NO.
.063 THK AL 6061-T6 (AMS-QQ-A-250/11)	SAMUEL / ALCOA INC	371069

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	N/A
2	REF. GFI MANUFACTURING JOB NUMBER J0226099-001 (2 PCS)		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **15 FEBRUARY 2011**

G.F.I. Q.C. REP. Dalton Hamilton

GFI CONTRÔLE QUALITÉ ISO 9001:2008

180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

ISO 9001:2000 CERTIFICATION Intertek

BON DE LIVRAISON / *SHIPPING MEMO*

DATE DE LIVRAISON / *SHIPPING DATE* JR - DY	MO - MO	AN - YR	N° DE BON DE LIVRAISON *SHIPPING MEMO NO.*	PAGE
14	02	11	0455817	1/1

VENDU À / *SOLD TO*

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

EXPÉDIÉ À / *SHIP TO*

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT *CUSTOMER CODE*		N° DE CONTRAT *JOB NO.*	VOTRE N° DE COMMANDE *YOUR PURCHASE ORDER NO.*	EXPÉDIÉ PAR *SHIP VIA*
DART	GFI-0299	0226099	PO13307	

QUANTITÉ *QUANTITY*	N° DE PIÈCE *PART NO.*	DESCRIPTION
2	D4055-5P	TANK UPPER CUT OUT CERTIFICATE OF CONFORMANCE REQ

MFG. JOB# J0226099-001 **QTY** 2

GFI 8 CONTRÔLE DH

EXPÉDITEUR *SHIPPER*

N° DE BON DE LIVRAISON *SHIPPING MEMO NO.*

REÇU PAR / *RECEIVED BY*

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

LES MÉTAUX SPÉCIALISÉS SAMUEL

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2008 + AS9100B

LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Date: DECEMBER 01,2010

Company Name: GFI Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe-Claire Qc
Zip Code: H9R 1A1

du client: 0077675 **# de commande SSMQ:** 012204
Customer's order #: **SSMQ's Order #:**

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
01	2	.063" X 48" X 144"	6061 T6	AMS-QQ-A-250/11	371069

5/02/17

Bien à vous,
Yours truly,

INSPECTION 12 SAMUEL

LES MÉTAUX SPÉCIALISÉS SAMUEL, 21525 CLARK-GRAHAM. BAIE d'URFÉ, QUÉBEC H9X 3T5 TÉL: 514-457-3399
SAMUEL SPECIALITY METALS, 21525 CLARK-GRAHAM, BAIE D'URFÉ, QUÉBEC H9X 3T5 FAX: 514-457-9393

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.
Per:

Malcolm Murphy
Director of Manufacturing Davenport Works

Kenton P. Young
Quality Assurance Manager

1163116 0

Ship Date	B.L. No.	Invoice No.	Alcoa No. Item	Page 1
2010-09-11	5158005	00000	1000221841-1	DCE-21841-1

P.O. No./Govt Contract No.	Customer	Alcoa Item
C62699 Ln#: 1	SAMUEL SON & CO LT G041110647R05	

Ship To: SAMUEL SON & CO LTD
S.S.M.Q
21525 CLARKE-GRAHAM
BAIE D'URFE H9X 3T5 QC

Item Description
0.063 IN TK (+0.0000 -.0035) X 48.0 IN W (+.125 -.125) X 144.0 IN LN (+.15625 -.15625) (N) A/T 6061-T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE GUARANTEED. AMS4027 REV N EXC_MRK ASME-SB-209 REV 07 EXC_MRK ASTMB209 REV 07 CMMP025 REV S ((MARKED)) KRAFT PAPER INTERLEAVED MAX GROSS
SKID WGT: 4500 LB QUAN TOL +/-30 %
CQR 0222751 REV 04 CUST REQ 10-09-07 *** W/E 10-09-11 ***

SAMUEL INSPECTION 7

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	239163	371069	1609	40	PC	27088 47004
2	239166	371069	4061	100	PC	27088 47004
3	239168	371069	4061	100	PC	27088 47004
			9731	240		

11/02/17

Notes for CQR: 0222751.4
PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 ORIGINAL REVISIO N DATED 1997-08-01.

CQR: 0222751.4 -Specification Limits

Tmpr	Dir		UTS KSI	TYS KSI	EL4D PCT
T6	Long Transv.	Max			
		Min	42.0	35.0	10

Chemical Composition

		SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 6061	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15	
	Min	0.40		0.15		0.8	0.04					REMAIN

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.
Per:

Malcolm Murphy
Director of Manufacturing Davenport Works

Kenton P. Young
Quality Assurance Manager

1163116	0			
Ship Date	B.L. No.	Invoice No.	Alcoa No. Item	Page 2
2010-09-11	5158005	00000	1000221841-1	DCE-21841-1
P.O. No./Govt Contract No.	Customer		Alcoa Item	
C62699 Ln#: 1	SAMUEL SON & CO LT G041110647R05			

CQR: 0222751.4 -Specification Limits (cont.) ----------
Lot: 371069 - Mechanical, Physical, Metallography, Quantometer Results ----------

Tmpr	Dir	No->	UTS	TYS	EL4D
		Test	KSI	KSI	PCT
T6	Long	2	51.1 ✓	45.7 ✓	10.4 ✓
	Transv.		50.8	45.3	10.3

Cast Number		SI	FE	CU	MN	MG	CR	ZN	TI
H9795095	Chemical - OES Actuals	0.66 ✓	0.4 ✓	0.28 ✓	0.03 ✓	1.0 ✓	0.20 ✓	0.03 ✓	0.02 ✓

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States

SAMUEL INSPECTION 7